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D2721-042
Job Sheet 206266



Part No: D2721-042

Job Qty: 4 pcs

Part Name: 206B Step Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/28/20

Job Tracking No:

Due Date: 2/12/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV D IPP Rev:F As Per Ecn 766 06-01-06 JLM IPP Rev:G add wing walk DD 10.02.24 verified by:EC
Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier	Lead Time	Sign-off
100	Large Fab - Steps - 1	4 pcs		2/12/20	0.00	1.00	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		<i>Art M.</i>
							Large Fab - 11 (Various)		
							Large Fab - 12		
110	Large Fab - Steps - 2 - B4B	4		2/12/20	0.00	8.29	Large Fab - 1 - B4B		
							Large Fab - 10 - B4B		<i>SL</i>
							Large Fab - 2 - B4B		
							Large Fab - 3 - B4B		
							Large Fab - 4 - B4B		
							Large Fab - 5 - B4B		
							Large Fab - 6 - B4B		
							Large Fab - 7 - B4B		
							Large Fab - 8 - B4B		
							Large Fab - 9 - B4B		
							Large Fab - 11 - B4B (Various)		
							Large Fab - 12 - B4B		
120	QC 9	4 pcs		2/12/20	0.00	0.00	QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		
							QC 9 - 50		
							QC 9 - 9		



Container No: S252916



Part: D2721 - 042

Job No: 206266

Serial No/Batch: S252916

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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Date: 02/03/20

Plex 1/28/20 12:56 PM Dart.lajeunesse.marie

130 QC 5	4 pcs	2/12/20	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
140 Handfinish - 1-1 Chemical-B4B	4 pcs	2/12/20	0.00 0.94	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
150 QC 3	4 pcs	2/12/20	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	

					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
					QC 3 - 61	
					QC 3 - 81	
					QC 3 - 82	
160 Large Fab - Steps - 3 - B4B	4 pcs	2/12/20	0.00 8.29		Large Fab - 1 - B4B	
					Large Fab - 10 - B4B	
					Large Fab - 2 - B4B	
					Large Fab - 3 - B4B	
					Large Fab - 4 - B4B	
					Large Fab - 5 - B4B	
					Large Fab - 6 - B4B	
					Large Fab - 7 - B4B	
					Large Fab - 8 - B4B	
					Large Fab - 9 - B4B	
					Large Fab - 11 - B4B (Various)	
					Large Fab - 12 - B4B	
170 QC 9	4 pcs	2/12/20	0.00 0.00		QC 9 - 10	
					QC 9 - 18	
					QC 9 - 24	
					QC 9 - 43	
					QC 9 - 50	
					QC 9 - 9	
180 QC 5	4 pcs	2/12/20	0.00 0.00		QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
190 Handfinish - 1-2- Chemical- B4B	4 pcs	2/12/20	0.00 0.94		Handfinish - 1 - 1 - B4B	
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	

					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
200 Powdercoat - 1 White Gl(A)- B4B	4 pcs	2/12/20	0.00 0.58		Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	
					Powdercoat - 4 - B4B	
210 QC 3	4 pcs	2/12/20	0.00 0.00		QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
					QC 3 - 61	
					QC 3 - 81	
					QC 3 - 82	
220 Handfinish - 3-1- WingWalk- B4B	4 pcs	2/12/20	0.00 0.94		Handfinish - 3 - 1 - B4B	
					Handfinish - 3 - 2 - B4B	
					Handfinish - 3 - 3 - B4B	
					Handfinish - 3 - 4 - B4B	
					Handfinish - 3 - 5 - B4B	
230 QC 3	4 pcs	2/12/20	0.00 0.00		QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	

240 Packaging 3-1 - Stock - B4B	4 pcs	2/12/20	0.00 0.00	QC 3 - 43	
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
				QC 3 - 82	
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				g 3 - 20 - B4B	
				g 3 - 21 - B4B	
				g 3 - 22 - B4B	
				g 3 - 23 - B4B	
				g 3 - 24 - B4B	
				g 3 - 25 - B4B	
				g 3 - 26 - B4B	
				g 3 - 27 - B4B	
				g 3 - 28 - B4B	
				g 3 - 29 - B4B	
				g 3 - 30 - B4B	
				g 3 - 31 - B4B	
				g 3 - 32 - B4B	
				g 3 - 33 - B4B	
				g 3 - 34 - B4B	
				g 3 - 35 - B4B	
				g 3 - 36 - B4B	
				g 3 - 37 - B4B	
250 QC 21 - SA	4 pcs	2/12/20	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	

Op 100 → Used DT 10463
to drill Vent Hole

Part Op 100 - Fabricate per Drwg - Cut D2721-2 using D2622 extrusion as per Dwg D2721 Deburr and bevel ends for welding
 Descriptions: DRILL VENT HOLE AS PER SECTION A-A
 110 - Fabricate per Drwg - Weld end cap (One End Only) and lugs as per Dwg D2721 using Jig DT10235 A followed by Jig DT10235B A/R AL Rod Batch: _____ Grind end cap welds flush
 120 - QC9- Inspect visual per QSI004- Fusion Welds
 130 - QC5- Inspect part completeness to step on W/O
 140 - Chemical Conversion Coat per QSI005 4.1)
 150 - QC3- Inspect Part Finish
 160 - Large Fab - Inspect for foreign object per QSI 024 Weld Remaining end cap as per Dwg D2721 BLOCK VENT HOLE USING RIVET AS PER DWG A/R AL Rod Batch: _____ Grind End Cap Welds Flush
 170 - QC9- Inspect visual per QSI004- Fusion Welds
 180 - QC5- Inspect part completeness to step on W/O
 190 - Chemical Conversion Coat per QSI005 4.1
 200 - White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum - START TIME: _____ OVEN TEMPERATURE: _____
 FINISH TIME: _____
 210 - QC3- Inspect Part Finish
 220 - Wing Walk as per dwg QSI005 4.4 Batch _____

230 - QC3- Inspect Part Finish

240 - Identify as per dwg & Stock Location:

250 - QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2622-120C	Step Extrusion	4 pcs (1 ea)	100-Large Fab - Steps - 1	S243427 ✓
D2734	Step End Plate	4 pcs (1 ea)	110-Large Fab - Steps - 2 - B4B	S242135 ✓
D3461-1	Mounting Plate	4 pcs (1 ea)	110-Large Fab - Steps - 2 - B4B	S072100 ✓
D3461-3	Mounting Plate	4 pcs (1 ea)	110-Large Fab - Steps - 2 - B4B	① S072102/S253003 ③ ✓
D3461-5	Mounting Plate	4 pcs (1 ea)	110-Large Fab - Steps - 2 - B4B	142383 ✓
D3461-7	Mounting Plate	4 pcs (1 ea)	110-Large Fab - Steps - 2 - B4B	B127723 ✓
MS20601-AD4W2	Rivet	4 Ea (1 ea)	110-Large Fab - Steps - 2 - B4B	S228472 ✓
D2734	Step End Plate	4 pcs (1 ea)	160-Large Fab - Steps - 3 - B4B	S242135 ✓

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Steps - 1	D2622-120C	4	133	0
110-Large Fab - Steps - 2 - B4B	D2734	4	34	0
	D3461-1	4	9	0
	D3461-3	4	5	0
	D3461-5	4	19	0
	D3461-7	4	8	0
	MS20601-AD4W2	4	38	0
160-Large Fab - Steps - 3 - B4B	D2734	4	34	0

Part Specifications

Specifications could not be found.

Plex 1/28/20 12:56 PM Dart.lajeunesse.marie

#110 MU: 014344 ✓

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: <u>206266</u> Part No. <u>D2721-042</u>	DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☒ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier Quality ☐		
Date : <u>20.02.12</u>	Sequence #: <u>100</u>	QTY Affected : <u>4</u>	MRB (QSI042)	
Description Work Order Deviation		Disposition		<u>PD 20-02-12</u> Completed By Lead hand / Supervisor <u>PD 20-02-12</u> QC / QA Coordinator <u>PD 20-02-12</u>
<u>Lug D3461-1/-3 was welded .250" outside tolerance</u>		<u>Scrap destroy no replace</u>		
Root Cause Operator ☒ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☒ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread		
		Other/Details:		